Date: Tuesday, 10/23/2007 2:38:32 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG AND BRACKET
Job Number	: 34208		
Estimate Number	: 11126		
P.O. Number	:	Part Number	: D301613
This Issue	: 10/23/2007 S.O. No. :	Drawing Number	: D3016 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 8/22/2007 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: 07-10-23.	Due Date	: 8/29/2007 Qty: ~~10~~ 15 Um: Each
Checked & Approved By	:		
Comment	: Est. B 03.05.09 Reformat KJ/RF		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M4130NS049	4130 Sheet .049 wall

3.828

Comment: Qty.: 0.2552 sf(s)/Unit Total : 2.5515 sf(s)
4130 Sheet .049 wall
Material: AISI 4130N Sheet, 0.049" thick(M4130N-S049)
Identify for D3016-13
Batch: M1643 IB 07-10-31

2.0	WATER JET	FLOW WATER JET

(15)

Comment: FLOW WATER JET
1-Cut as per Dwg D3016
Dwg Rev: A IB 07-10-31
Prog Rev: A

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-10-31

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

counter

Comment: SECOND CHECK IB 07/10/31 (X15)

5.0	BRAKE NC	NC BRAKE

Comment: NC BRAKE
Form D3016-13 as per Dwg D3016 JB 07/11/06 (15)

Form: rprocess

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LUG AND BRACKET

Job Number: 34208 **Part Number:** D301613

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

7.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and bag with light oil (~~Vactra oil #2~~), then Stock
Location: 5726

8.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Form: rprocess

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

1) WELD PER DART QSI 004
2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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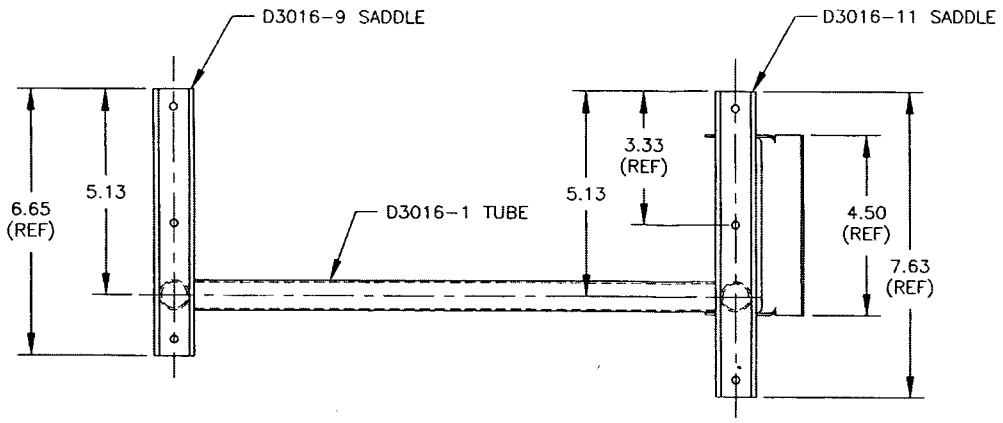
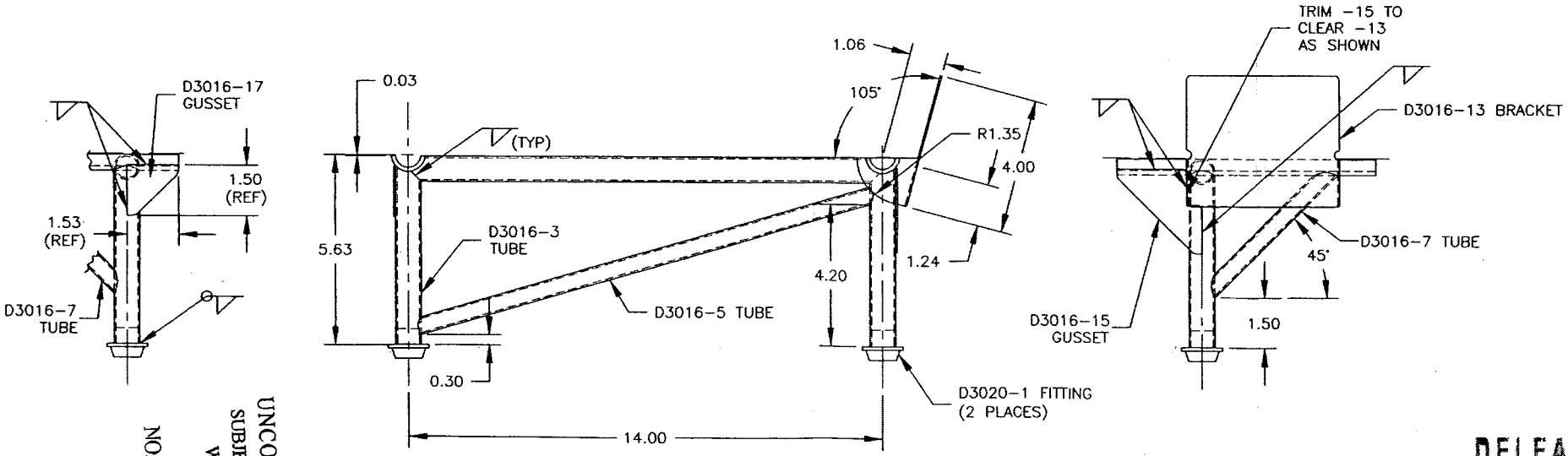
D3016-041 SEAT FRAME ASSEMBLY





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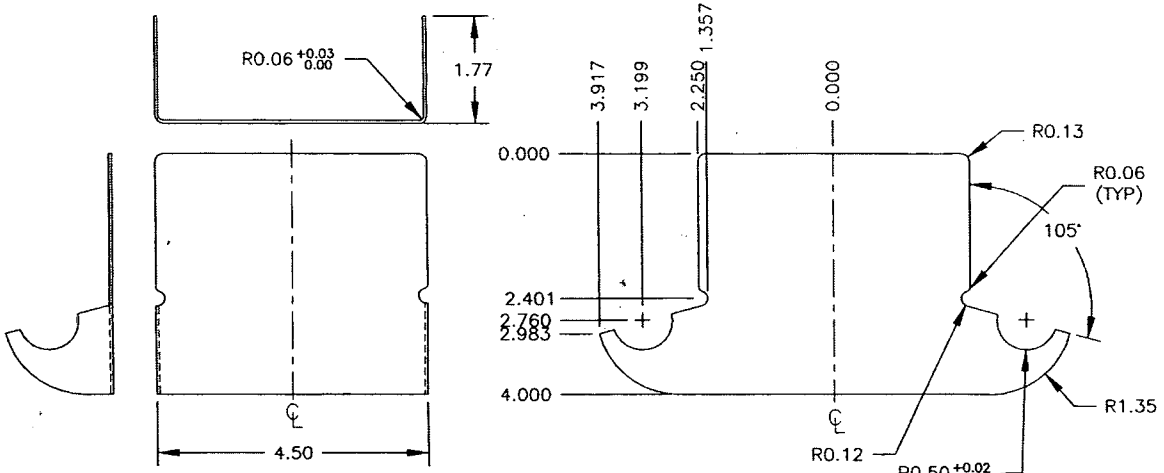
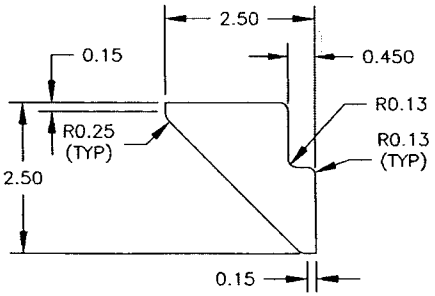
CHECKED	APPROVED	DRAWING NO. D3016	REV. A
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE 1:3



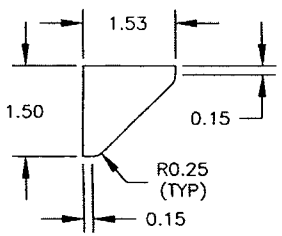
BENDING DETAIL

D3016-13 BRACKET

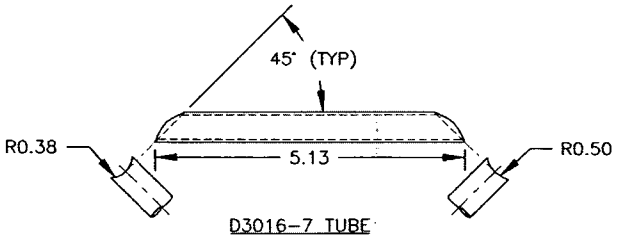
FLAT PATTERN



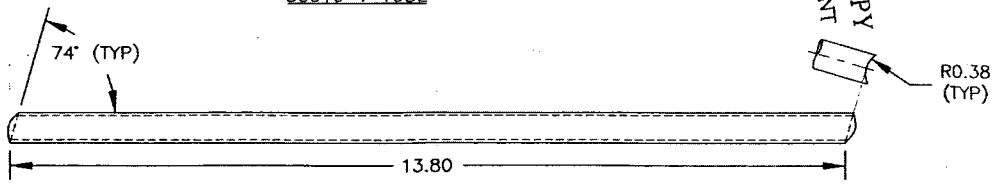
D3016-15 GUSSET



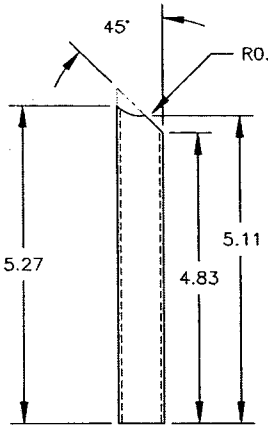
D3016-17 GUSSET



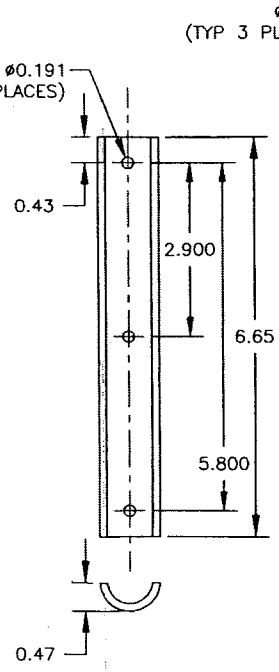
D3016-7 TUBE



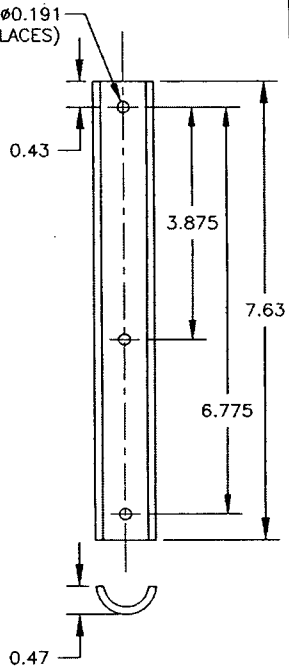
D3016-5 TUBE



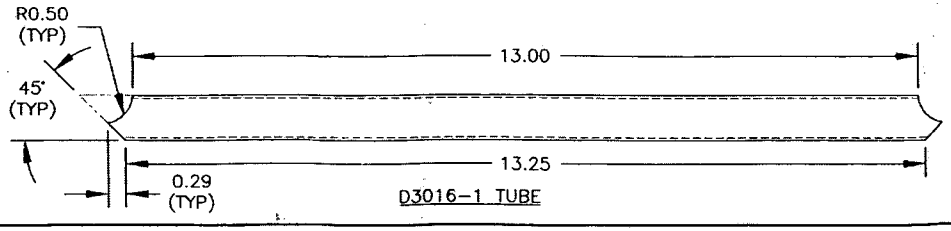
D3016-3 TUBE



D3016-9 SADDLE



D3016-11 SADDLE



D3016-1 TUBE

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CHECKED	APPROVED	DRAWING NO. D3016	REV. A
DATE 01.05.18			SHEET 3 OF 3
		TITLE SEAT FRAME ASSEMBLY	SCALE 1:2

DART AEROSPACE LTD	Work Order:	34208
Description: LUG AND BRACKET	Part Number:	D3016-13
Inspection Dwg: D3016-B Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.000	+/- .010	4.007	✓			
2.983	+/- .010	2.983	✓			
2.401	+/- .010	2.401	✓			
2.250	+/- .010	2.250	✓			

Measured by:	AB
Date:	07-10-31

Audited by:	
Date:	07/10/31

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	